

Work Order ID 55325

January 13, 2010 10:23:07 AM



Page 1

Item ID: D2154

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Bracket

Start Date: 1/13/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: *10-1-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2154

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2154 ☐ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary *SAD*

304 .003

10-01-21

IB 10-1-19

51

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 10-1-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

> S1010122

counter
(x20)

φ

Pls →

W/O: 55325

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/22	# 120	Took Qty x1 For inspection Template	S	10/1/22	x1		S 10/1/22

Part No: D2154 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55325

January 13, 2010 10:23:07 AM



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Item Name: Stud Bracket

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Deburr if necessary

SAD
10-01-21

21

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Form as per Dwg D2154Rev: C

8 10/03/10

20

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/03/10

count
10/03/10

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55325

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Item ID:	D2154	Accept		Setup	Start	
Revision ID:						
Item Name:	Stud Bracket				Stop	
Start Date:	1/13/10	Start Qty: 20.00				
Required Date:	1/20/10	Req'd Qty: 20.00				
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: 10:00AM OVEN TEMPERATURE: 10:30AM FINISH TIME: 3209	0.00 0.00				x20	Ø		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
180 Packaging Packaging	Identify as per dwg & Stock Location: ST007 Memo	0.00 0.00							

Prop/24 (20)

W/O:		WORK ORDER CHANGES						
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Item ID: D2154

Revision ID:

Item Name: Stud Bracket

Start Date: 1/13/10

Start Qty: 20.00

Required Date: 1/20/10

Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/03/24 *[Signature]*
MF
10-3-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:23:13 AM

Page 1

Work Order ID: 55325

Parent Item: D2154

Parent Item Name: Stud Bracket

Comments: IPP: C 03.08.08 Reformat; Remove Tumble KJ/RF
IPP Rev:D NowOn Waterjet 07-04-09 JLM

Start Date: 1/13/10

Required Date: 1/20/10

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	318.2779	0.7011			



304/316 Sheet .063



B 10-1-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

318.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

255.1895

(21)

113295

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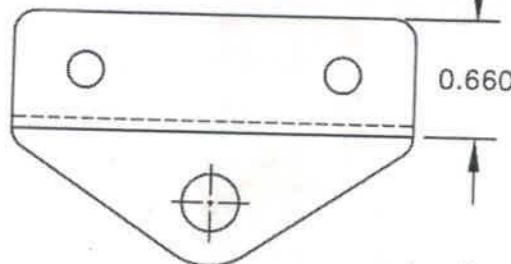
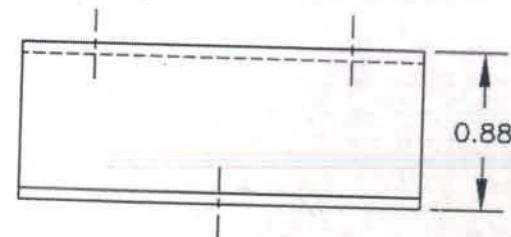
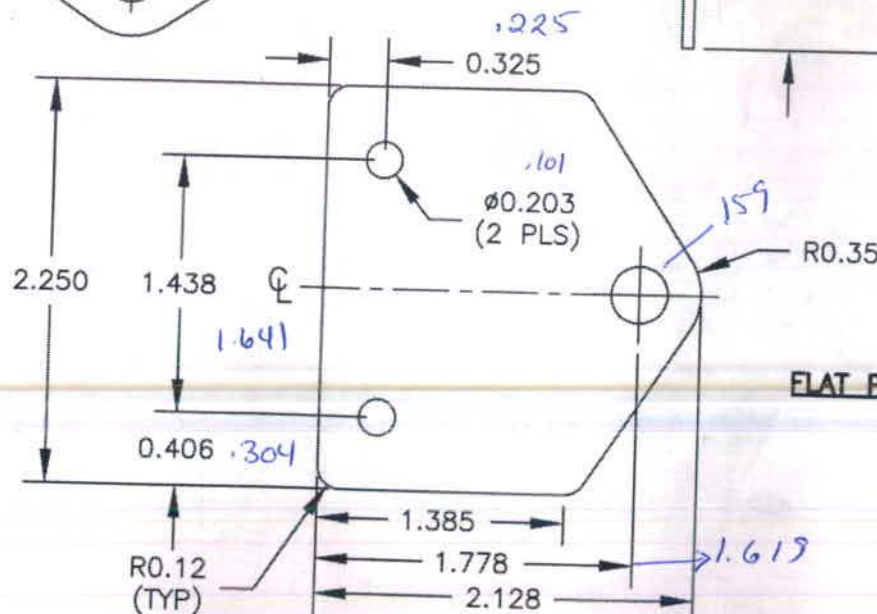
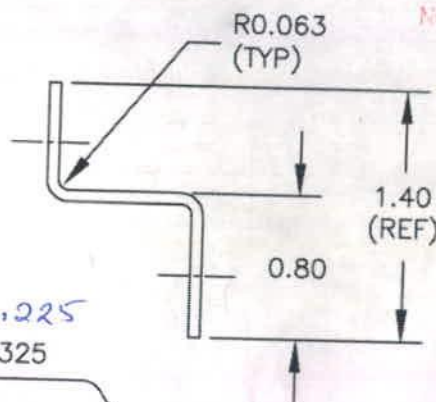
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DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED
04.10.15 *[Signature]*

**BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55325
2/10-1-73

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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